

OPERATION MANUAL

For GS-210 SLITTING MACHINE



Editor: Taicang Guangsheng Machinery Co.,Ltd 02/02/2018
Add:16 Dongan Road, Chengxiang Town, Taicang City, Jiangsu, China.
Tel: +86 512 53185098 Fax: +86 512 53129309

INDEX

SPECIFICATION.....	3
NOTICE: BEFORE USE.....	3
INSTALLTION & ALIGNMENT.....	4
PLANT LAYOUT.....	5
OPERATION PREPARING.....	6
BLADES MOUNTING.....	7
OPERATION PROCESS.....	8
SHAFT AUTO EXCHANGE.....	11
LABELLING ON END OF TAPE ROLL.....	11
SHAFT MANUAL EXCHANGE.....	11
OPERATION PANEL.....	12
REWINDGING SHAFT LOADING AND UNLOADINHG.....	14
CORE LOADING & UNLOADING MACHINE.....	14
LUBRICATION AND MAINTENANCE.....	15
INDUCTION SWITCH AND ADJUSTMENT.....	15
REWINDING SHAFT TENSION SETTING.....	15
EDGES TRIMMING (OF TAPE).....	15

TAI CANG GUANGSHENG MACHINERY CO.,LTD

SPECIFICATION:

[1] Working width	: max. 1600 mm
[2] Unwind diameter	: max. 600 mm
[3] Slitting width	: 12 - 1600 mm
[4] Rewind diameter	: 150 mm (3" core)
[5] Rewind speed	: 0-150 M/min. stepless
[6] Rewind tension	: spring clutch type
[7] Unwind shaft	: Air shaft & thread-lock shaft
[8] Unwind brake	: 10 kg/M pneumatic brake
[9] Length counter	: electronic, 3 steps
[10] Trimming device	: 1 set
[11] Motor	: 5 Hp with inverter
[12] Tools	: razor blade, 0.2 x 22 x 60 mm
[13] Expansion roller	: banana roller 100 mm diameter

NOTICE: Before Use

- [1] Do study this manual before operate the machine.
- [2] Do study all the function of machine before operation.
- [3] All of safe covers can not be moved while operation.
- [4] All of hand tools should be took away, before running the machine.
- [5] Do keep clean and empty around the operation area.
- [6] Any visitor should be advised to keep a distance while machine in running.
- [7] Do switch OFF, during maintenance or/and changing spare parts.
- [8] Before power ON, do inspect all switches at OFF position.
- [9] Do change any damaged parts in time to ensure the function of machine.
- [10] Do not leave away when the machine in operation, or switch OFF first.
- [11] Before shipping, the machine will coat with grease and oil for anti- rusted.
Do clean it before running. Do not use any solvents or/and petrol, just clean by waste clothes.

INSTALLTION & ALIGNMENT

[1] The foundation of this machine is NOT required.

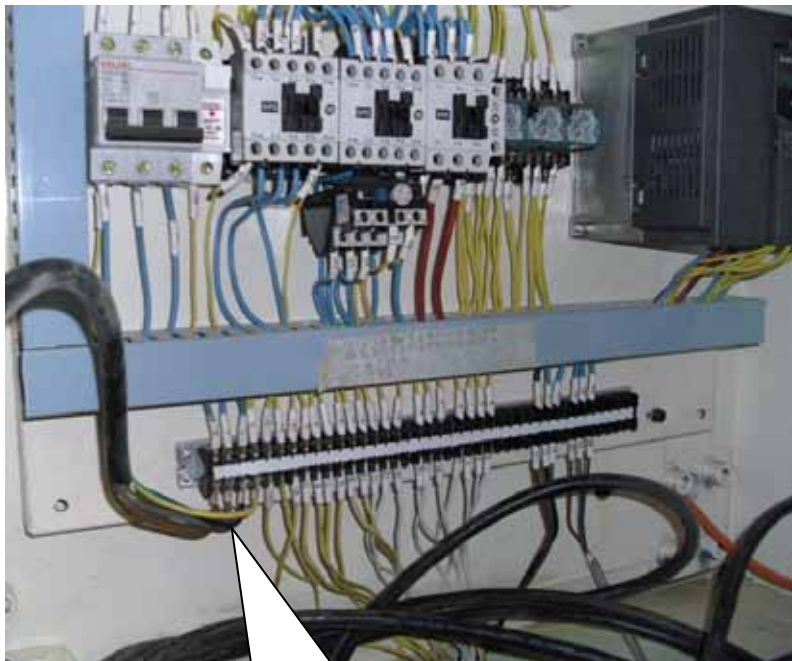
[2] Alignment of lever adjustment is required. There are 4 bolts at bottom for adjustment.



Lever adjustment.

[3] Before power connection, do confirm the voltage is suitable for motors.

[4] After power connection, please do inspect the direction of motors.



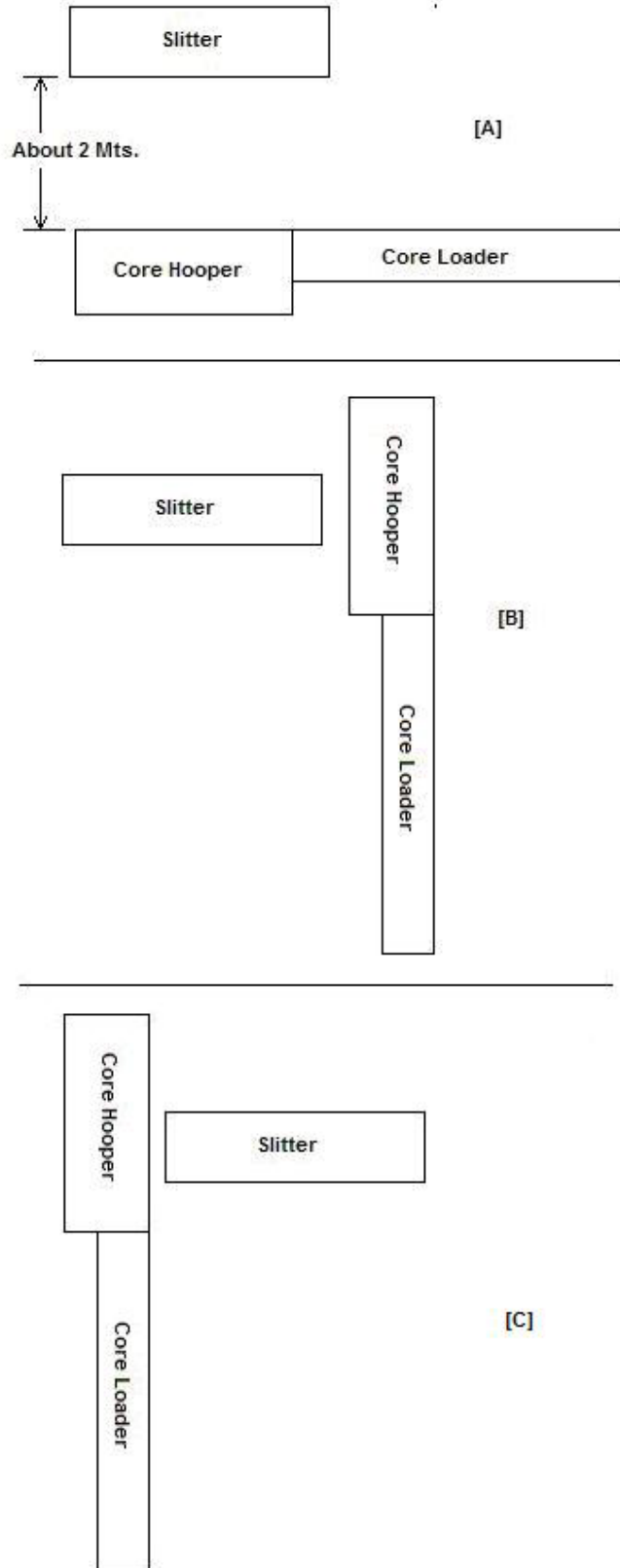
Here, your cable connection.

TAI CANG GUANGSHENG MACHINERY CO.,LTD

PLANT LAYOUT

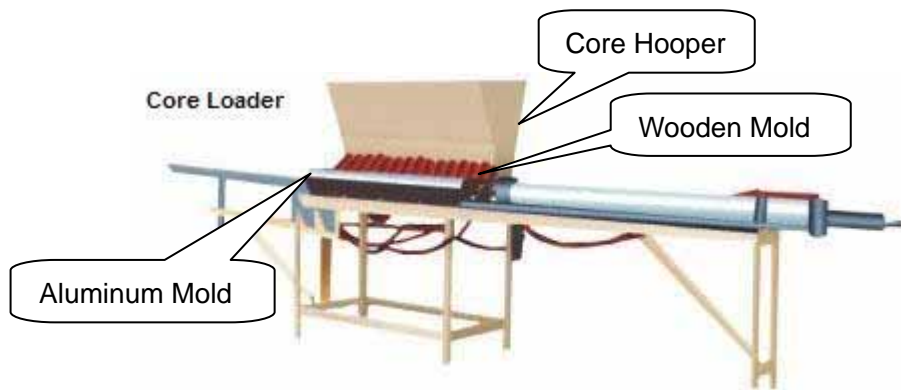
[1] To arrange the location of machine, by [A], [B] or/and [C] are workable, depend on your convenience.

PLANT LAYOUT



OPERATION PREPARING

[1] Different size tape (slit width) used different spacers, Aluminum mold and wooden mold. According to requirement then select and change it.



[2] To load jumbo roll on slit.

[a] Loosen the screws of unwind shaft, hand out the clip of shaft.



[b] To insert the shaft into jumbo core, then tight the clip and lock screws.

[c] To load jumbo roll on unwind station.



[3] To load paper core into hoper.

[4] To standby the (tape) End-labeling paper.

[5] To change proper size of spacer of blades, then fix on machine.

TAI CANG GUANGSHENG MACHINERY CO.,LTD

BLADES MOUNTING, Watch your hand !

- [1] Loosen right and left side's screws of blade holder.
- [2] Be carefully remove all of blades from holder.
- [3] Loosen 2 end lock screw.
- [4] To remove all blade spacers from holder.
- [5] Select proper width spacer and put it into blade holder, then insert the blades between 2 spacers, one by one.
- [6] Lock covering core, screws and handles on two sides
- [7] Lock blade holder with screws.

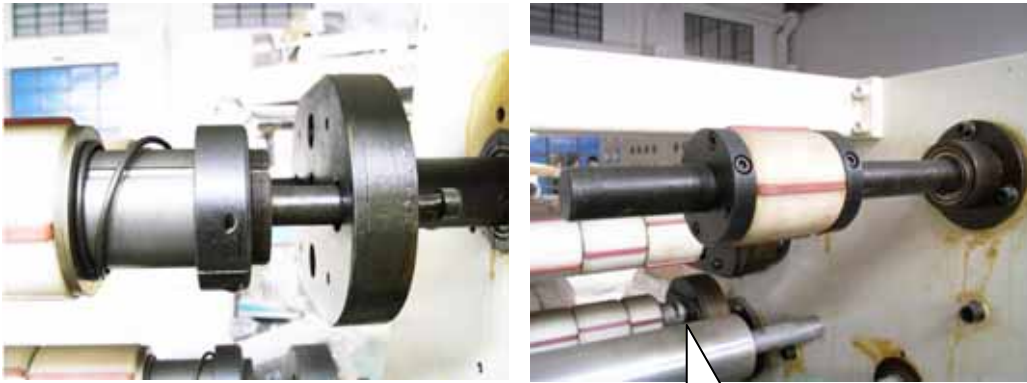


OPERATION PROCESS

After completed Operation Preparing, then

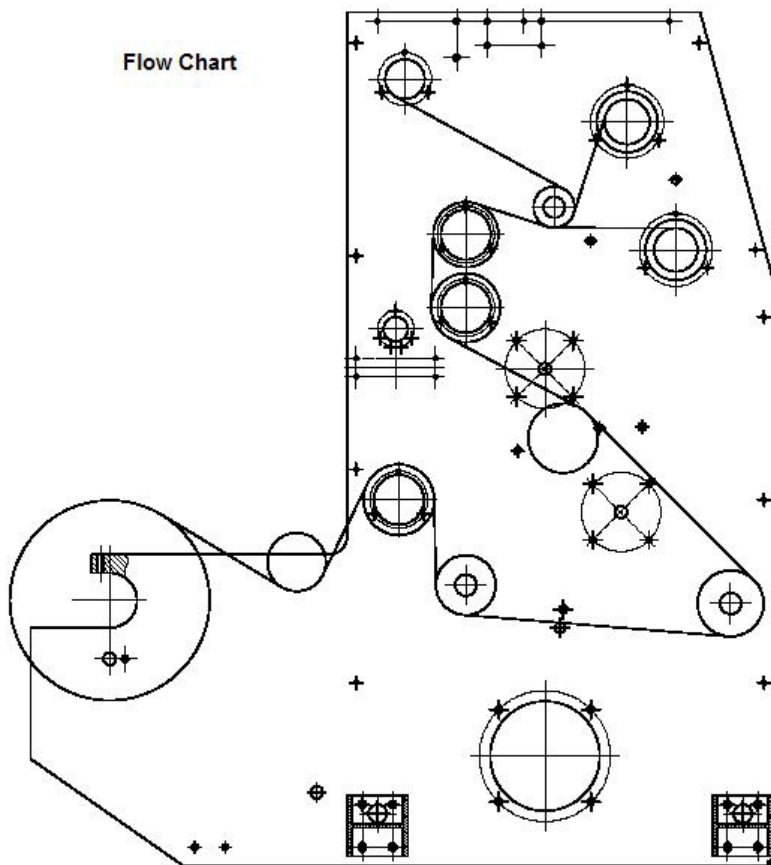
[1] To load the rewinding shafts on slitter:

- [a] Rotate and release shaft locker.
- [b] To put the shaft right end into the shaft holder.
- [c] To put the shaft left end into the shaft locker, then lock it.



Shaft locker

[2] take the OPP tape (film) pass through the rollers as following drawing.



[3] To adjust the position of jumbo roll.



[a] Let the blades to cut the minimum un-coated edges.

[b] The trim edges stick on trimming core.

[c] to stick one by one tape strap on each paper core on rewinding shafts.

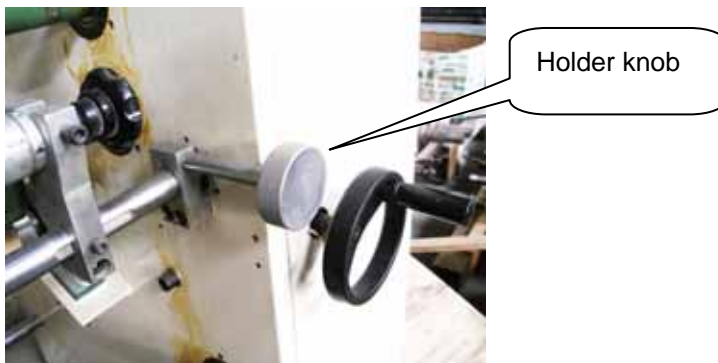


[4] To adjust the Cutting Angle

[a] Loosen blades holder knob.

[b] Rotate blades holder by hand-wheel until properly cut on the tapes.

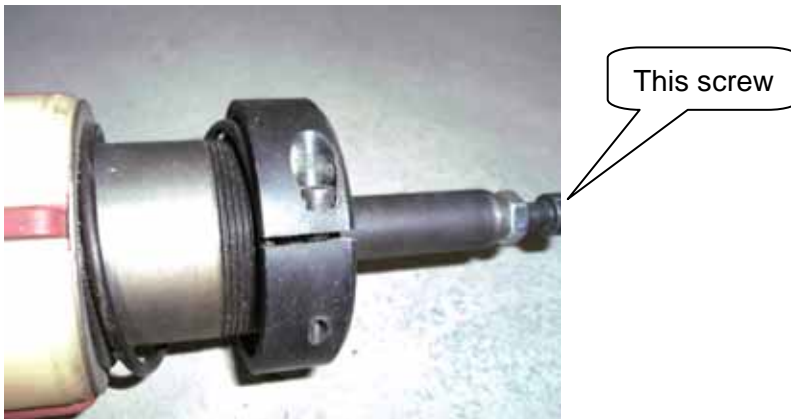
[c] After adjusted and fix the cutting angles then lock the screw.



TAI CANG GUANGSHENG MACHINERY CO.,LTD

[5] To adjust the position of paper core on rewinding shaft:

[a] Check the screw length (at right side) of rewinding shaft is proper or not.



[b] Check the size of Aluminum mold is proper or not,.

[c] To adjust the screw length of cylinder as required.

[d] To load the rewinding shaft on cylinder then load paper core.

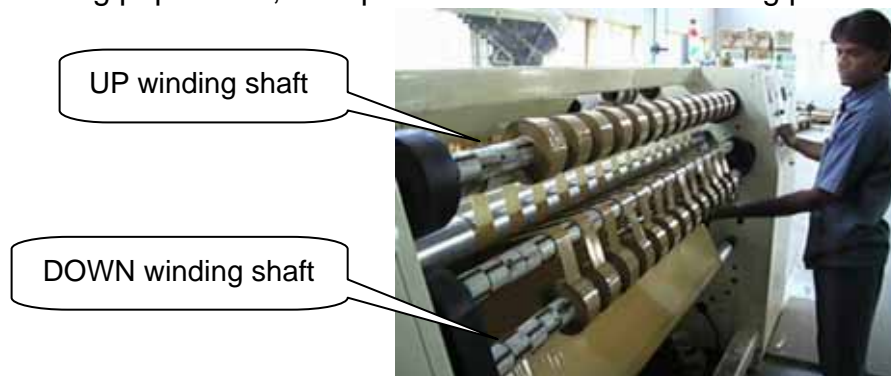


[e] To open Aluminum mold and check the position of paper core on shaft.

[f] If position is not properly, then adjust the screw of cylinder.

[g] Shaft unloading always UP shaft used for up position, DOWN shafts used for down position. The same, for manual switch on core loader, once loading the cores for UP shaft then switch to right; the opposite switch for down shaft.

[h] After loading paper core, then put the shaft on the rewinding place.



TAI CANG GUANGSHENG MACHINERY CO.,LTD

SHAFT AUTO EXCHANGE

- [1] Press the START button, the machine will run at First high speed.
- [2] When the length counter reach the first length, main motor will speed down and run at Second low speed.
- [3] When the length counter reach the send length, main motor will stop.
- [4] Labeling at the proper site.
- [5] Running at the Second low speed.
- [6] When the main motor stop, it will change shaft automatically.
- [7] The change direction is up to the obverse and inverse switch.
- [8] Two counters change to Reset at the same time.
- [9] Open rubber pressure wheel and unload the tape.

LABELLING ON END OF TAPE ROLL

- [1] Put the ticket on the set button of the left of machine platform.
- [2] Labeling on the underside smooth wheel after slitting.
- [3] Press the second start after labeling.



SHAFT MANUAL EXCHANGE

- [1] Press the START button, the machine will run at First high speed.
- [2] When the length counter reach the first length, main motor will speed down and run at Second low speed. .
- [3] When the length counter reach the send length, main motor will stop.
- [4] Labeling at the proper position.
- [5] Press the second start button, motor will run slowly at the third setting length.
- [6] Press manual change button to check if the label stick at proper place.
- [7] Two counters change to Reset at the same time.
- [8] Open rubber pressure wheel and unload slit tape.

OPERATION PANEL

1. Length Counter:

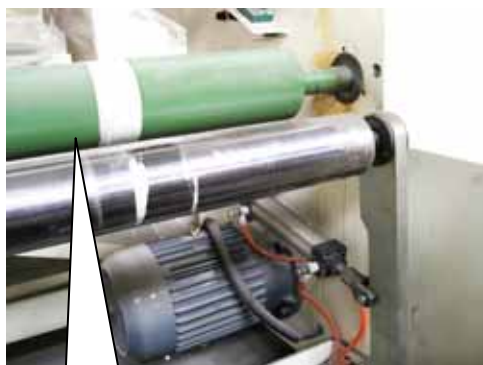


▲ How to set the required length:

[1] Press M, then the screen show “S E t.3” & digit “000000”

[2] Press  then the digit will be flashing, press more times to select the required digit. The same for  and so on.

[3] These digit is mention “cycle” of mesh roller.



Mesh roller



Counter sensor

[4] The OD of mesh roller is 106 mm, thus the circle is 333 mm, or may calculate 3 cycles is 1 meter.

[5] Press M again, then the screen show “S E t.2” & digit “000000”

[6] “S E t.2” is setting for end labeling, usually this digit may be set 5 cycles less than “S E t.3”.

[7] Press M again, then the screen show “S E t.1” & digit “000000”

[8] “S E t.1” is setting for starting slow down the running speed, usually this digit may be set 30 cycles less than “S E t.2”.

[9] For example: produce 50 meters roll, then setting digit of “S E t.3” at “150”, Then, “S E t.2” at “145” and “S E t.1” at “115”. Do try one operation then fine adjustment the final digits.

2. Operation Panel



3. **ON & OFF:** it's main power switch.
4. **MAN. & AUTO.:** it's selection switch, to select how to exchange for "rewinding shafts". When select AUTO, then, after rewinding operation is accomplished, it will change shaft automatically. If MAN., then, exchange manually.
5. **START:** when push this button, the Motor will be running (rewinding).
6. **SECOND START:** when push this button, the machine will re-start again.
7. **ONE SPACE:** when push this button, the machine will STEP running.
8. **CHANGE RIGHT/CHANGE LEFT:** Manual change jumbo roll right/left switch. Press the switch, machine performs jumbo roll change manually, but it only works when you put Automatic/manual switch on Manual site.
9. **STOP:** it's a emergency stop.
10. **SPEED SET:** operation speed, it's a variable switch, stepless.

REWINDING SHAFT LOADING AND UNLOADING

1. After the tape finished slitting, then unload the rewinding shaft.
2. Rotate gear-pack bottom at inverse side, and loosen clip.
3. Push rewinding shaft a little right and take it out.
4. Please operate on the contrary of the above way when loading the rewinding shaft.

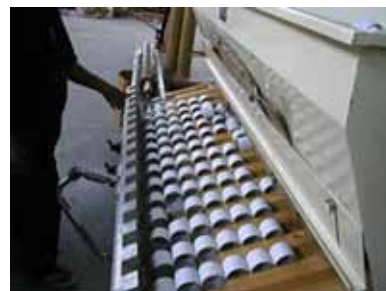


CORE LOADING & UNLOADING MACHINE

1. Do check size of Aluminum mold and wooden mold.
2. Do check paper cores (on winding shaft) into pitch; if not, then adjust the screw of cylinder to the needful width.



3. Rewinding shaft loading. Move manual switch on left and put rewinding shaft the side with screw into pressure vat interface, and then move manual switch right. So paper core gone through rewinding shaft. Open handle of aluminum model to check whether the paper core is on the proper site. Adjust the screw of cylinder to make paper core at the middle of cover
4. Shaft unloading. The same operation way as above, but needs to move one more switch.
5. After rewinding shaft with paper core on it to put the shaft on the rewinding place. Make sure the edge of upside paper core is the same as the underside one.



TAI CANG GUANGSHENG MACHINERY CO.,LTD

LUBRICATION AND MAINTENANCE

1. Check unloading shaft and braking pieces of scrap shaft regularly. If the braking pieces were broken badly, you should change a new one at once.
2. If every gearing chain is lack of grease. Inject grease at once.
3. No need to lubricate again for the gear-pack because it was lubricated well before send out from factory.

INDUCTION SWITCH AND ADJUSTMENT

1. All the induction switches of this machine are at fixed point way. No need to adjust.
2. Counter induction. Four influence points with three-step length setting. It can provide extremely smooth operation and a stable braking.
3. Change shaft induction: Once the shaft change, the counter will count one time.

REWINDING SHAFT TENSION SETTING

1. Tension of the tape on rewinding shaft was controlled by screw adjustment tension.
2. Tape tension increases when you turn screw at obverse side; tape tension decreases when you turn screw at inverse side.



EDGES TRIMMING (of tape)

1. Adjust trimming shaft to be sure it'll rewind the edges properly.
2. manually Operate till edges is enough to trim and winding properly.
3. Rewinding trim tape automatically while slitting.